

Date: Thursday, 27/11/2008 2:23:45 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE, OUTBOARD, RH, 206
<b>Job Number</b> : 43808	
<b>Estimate Number</b> : 10523	
<b>P.O. Number</b> :	<b>Part Number</b> : D26652
<b>This Issue</b> : 27/11/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2665 REV. D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 41975	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/12/2008 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08.11.27</u>	
<b>Comment</b> : Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC Est Rev:D As per Rev D 07-03-19 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)  
 7075-T7351 2X6.25X7.875  
 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length

ml 08/12/31

Batch: B34873

8

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 1- Program batch number  
 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet  
 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet  
 4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet  
 5- Deburr

ml 08/12/31

8

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

ml 08/10/05

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 08/12/31

8

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

JL 08/10/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 27/11/2008 2:23:45 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 43808

Part Number: D26652

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HS

09-01-07

(X8)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:10

OVEN TEMPERATURE:

320°

FINISH TIME:

9:40

FX 09/01/07

(8)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-07-01

(XV)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 436

9/1/7

8X

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/07

MF 09-01-07

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43808
<b>Description:</b> 206 Saddle, Outboard, Right side		<b>Part Number:</b> D2665-2
<b>Inspection Dwg:</b> D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.106	.112	.112	.111		
B	0.100	0.140		.117	.120	.120	.119		
C	1.125	1.145		1.135	1.139	1.136	1.136		
D	0.615	0.685		.685	.680	.680	.675		
E	0.240	0.260		.245	.249	.254	.253		
F	1.313	1.343		1.320	1.321	1.327	1.327		
G	0.210	0.230		.214	.222	.223	.223		
H	0.100	0.180		.141	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.574	1.572	1.576	1.575		
K	0.235	0.240		.236	.236	.236	.236		
L	0.100	0.120		.113	.112	.112	.112		
M	0.990	1.010		1.000	1.000	1.001	1.002		
N	0.510	0.515		.510	.511	.510	.510		
O	5.990	6.010		5.997	5.999	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.315	.315	.315	.315		
S	0.315	0.322		.321	.321	.321	.321		
T	2.495	2.505		2.499	2.500	2.500	2.500		
U	1.357	1.367		1.360	1.361	1.361	1.361		
V	0.787	0.807		.794	.792	.792	.794		
W	0.540	0.560		.549	.550	.549	.549		
X	1.674	1.684		1.678	1.680	1.680	1.678		
Y	0.257	0.262		.260	.260	.259	.260		
Z	0.912	0.932		.921	.922	.924	.922		
AA	0.490	0.510		.499	.499	.501	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>mf</i>
Date:	08/12/31

Audited by:	J.L
Date:	09/01/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

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B	0.100	0.140		.121	.121	.122	.121		
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D	0.615	0.685		.680	.680	.680	.680		
E	0.240	0.260		.253	.255	.253	.253		
F	1.313	1.343		1.327	1.327	1.326	1.326		
G	0.210	0.230		.223	.223	.223	.223		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.575	1.575	1.575		
K	0.235	0.240		.236	.236	.236	.236		
L	0.100	0.120		.110	.110	.110	.112		
M	0.990	1.010		1.001	1.002	1.001	1.001		
N	0.510	0.515		.510	.510	.512	.511		
O	5.990	6.010		6.000	6.000	5.999	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
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T	2.495	2.505		2.490	2.499	2.500	2.500		
U	1.357	1.367		1.363	1.363	1.361	1.360		
V	0.787	0.807		.793	.794	.796	.796		
W	0.540	0.560		.549	.549	.548	.548		
X	1.674	1.684		1.680	1.680	1.677	1.679		
Y	0.257	0.262		.259	.259	.259	.259		
Z	0.912	0.932		.922	.922	.919	.920		
AA	0.490	0.510		.502	.501	.501	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

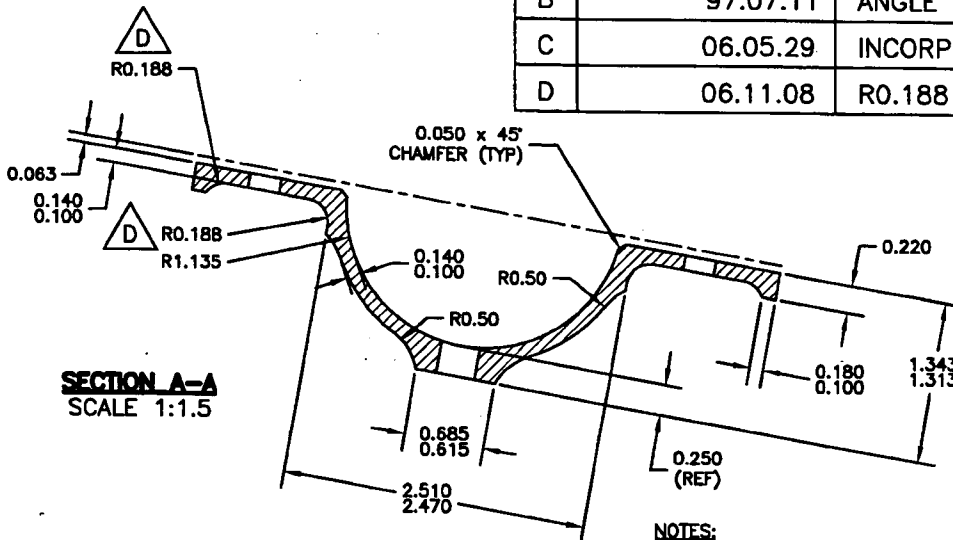
Measured by:	<i>[Signature]</i>
Date:	09/01/02

Audited by:	JL
Date:	09/01/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2665	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3	
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



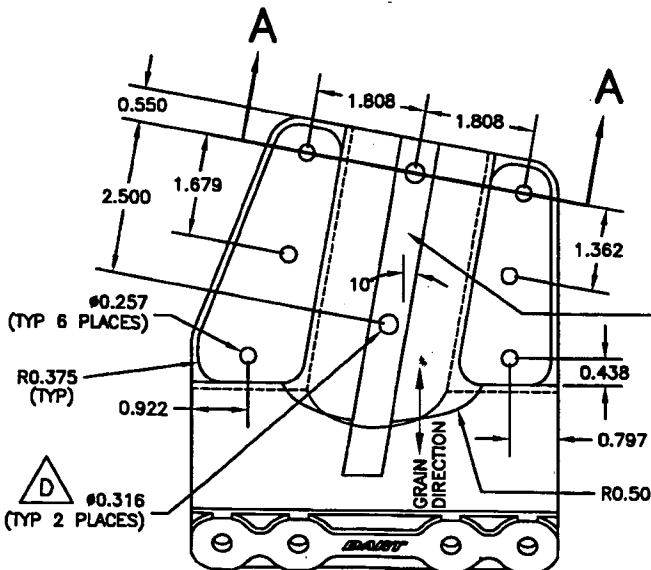
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07.02.12

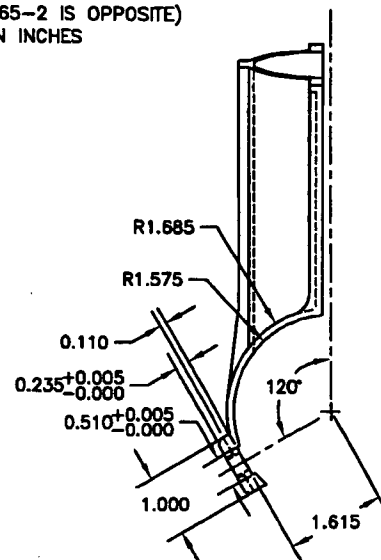
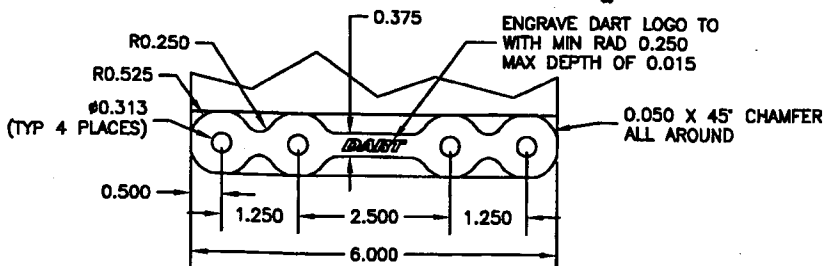
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43808

## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010

**D2665-1 SADDLE FWD OUTSIDE HIGH**

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